

Date: Wednesday, 07/01/2009 12:42:54 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HEAD REST
Job Number : 44448	
Estimate Number : 10738	
P.O. Number :	Part Number : D3303041
This Issue : 07/01/2009 S.O. No. :	Drawing Number : D3303 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 41188	Material :
Written By :	Due Date : 31/01/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JLD 09.01.09</u>	
Comment : Est: B 04.10.05 Revised Step 5 with headrest identification K J/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D3303043	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

BRACKET ASSEMBLY

Pick:

Qty	Part Number	Description	Batch
1	D3303-043	Bracket Assembly	B41650

2.0	D33051	Cushion
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

FOAM CUSHION

Pick:

Qty	Part Number	Description	Batch
1	D3305-1	Cushion	B40909 (7K)

B41200 (5X)

3.0	D3306041	Cover Assembly
-----	----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

COVER ASSEMBLY

Pick:

Qty	Part Number	Description	Batch
1	D3306-041	Cover Assembly	B40910

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 07/01/2009 12:42:54 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 44448

Part Number: D3303041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L adhesive. Identify as D3303-041

A/R 3M 1300/1300L Adhesive Batch: M109410

2- Cover Head Rest with D3306-041 as per Dwg D3303

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303, then Stock

Location: ST 180

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

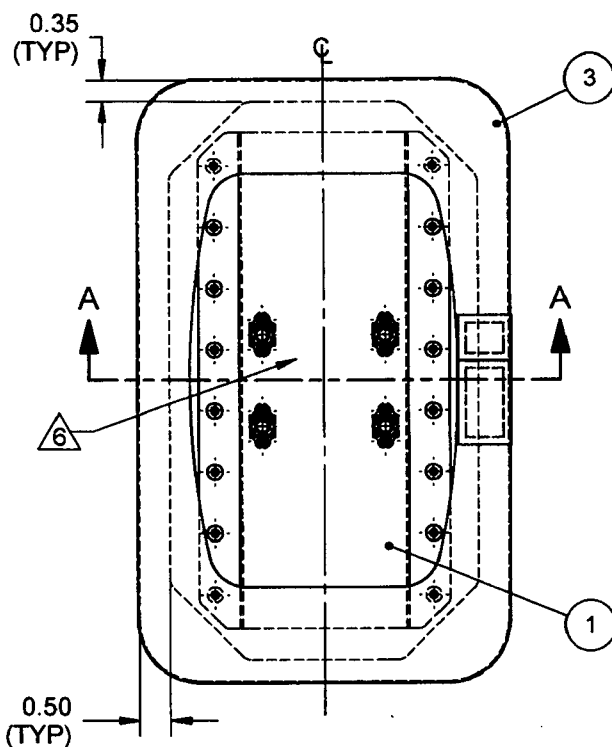
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

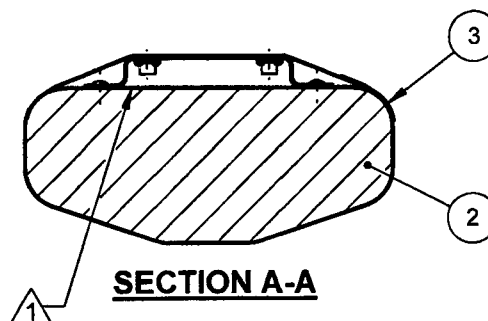
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:3
REV A	DATE 04.08.18	DESCRIPTION NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	



RELEASED

06-09-19 *PH*

DEO ATTACHED

**D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO *11448*

NOTES:

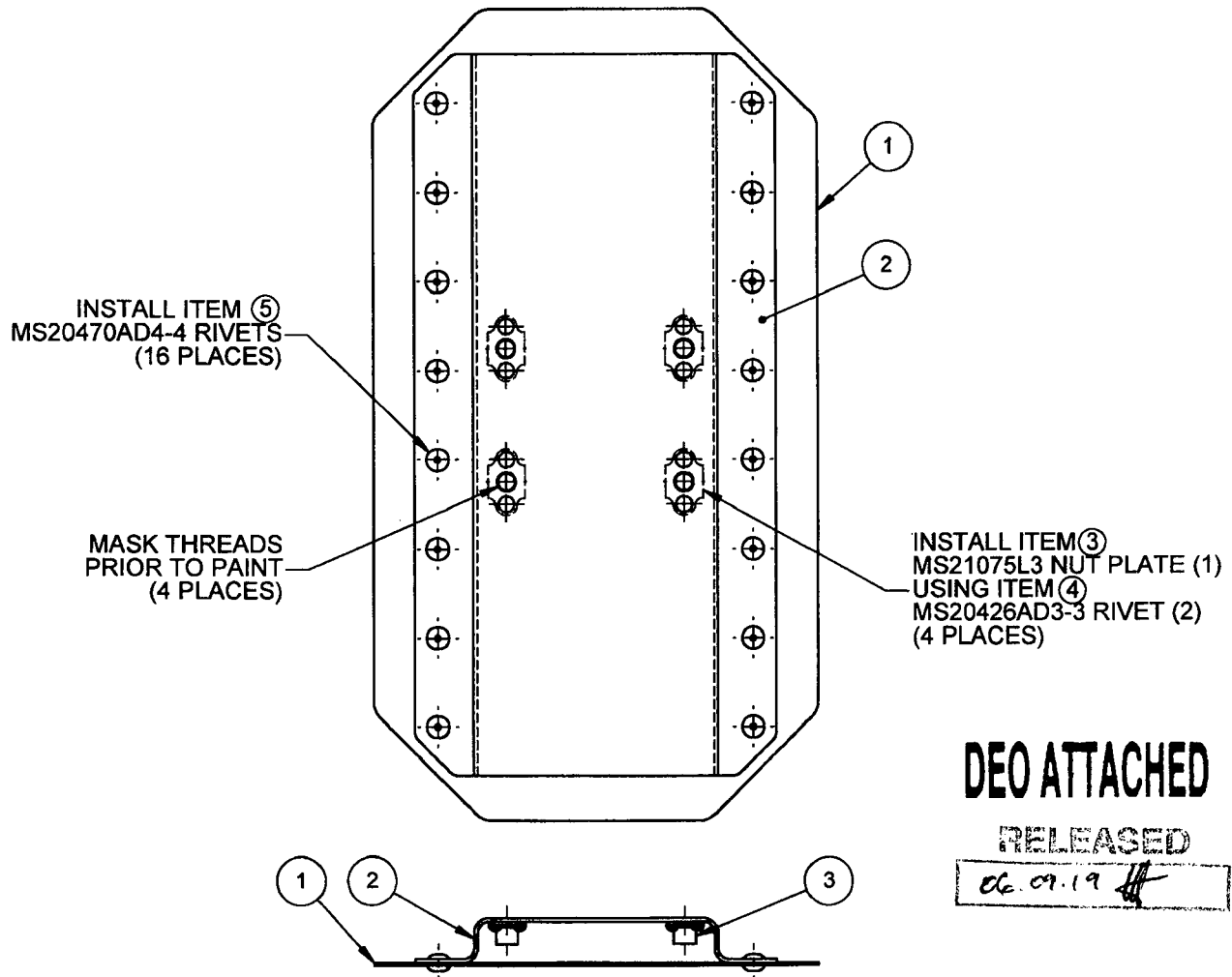
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST SCALE 1:2	



DEO ATTACHED
RELEASED
06.09.19 *[Signature]*

D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

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WORK ORDER
NO. *[Signature]*

NOTES:

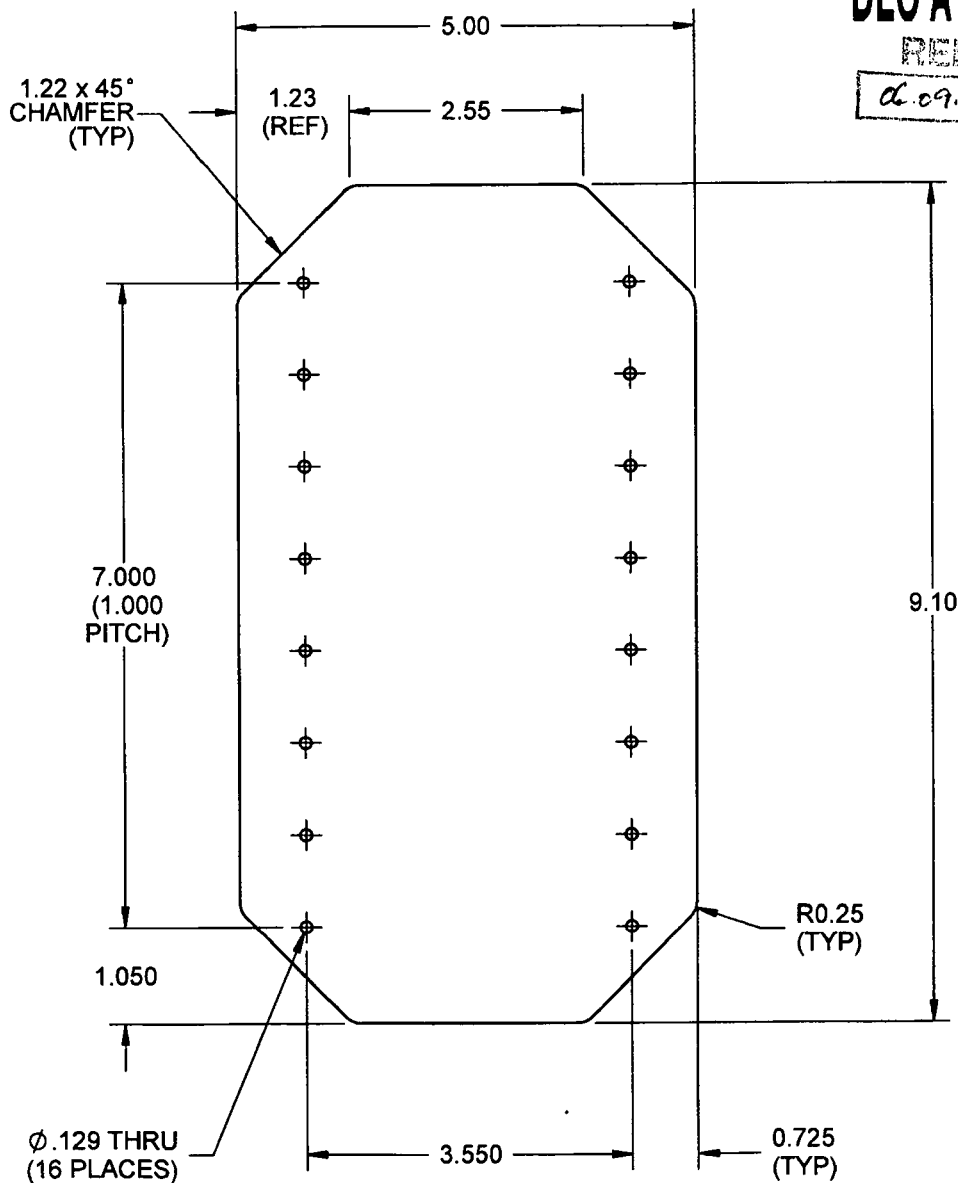
- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



DEO ATTACHED

RELEASED

09.14 *[Signature]*

D3303-1 PLATE

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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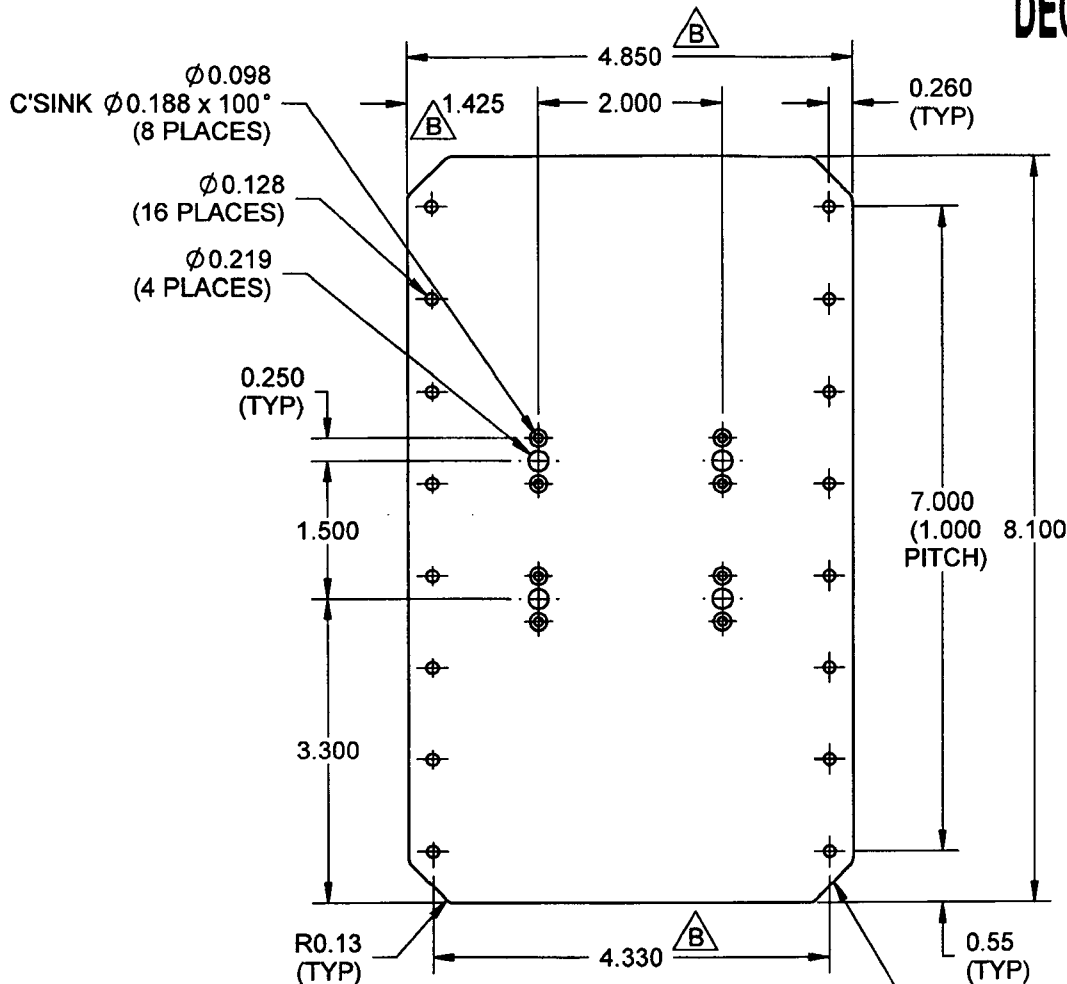
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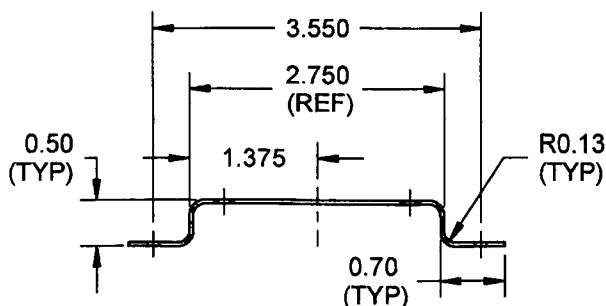
DESIGN <i>PH</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

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D3303-3F BRACKET FLAT PATTERN

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WORK ORDER
NO 44448



D3303-3 BRACKET BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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DRAWING NO. D3303	TITLE HEAD REST	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3303-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>h</i>	DE APPR. <i>h</i>			
DATE 08.10.15	DATE <i>08.10.15</i>	DATE <i>08/10/16</i>	DATE <i>08/10/16</i>	DATE <i>08/10/16</i>			

SHEET 1 ADD 1300L ADHESIVE BY 3M TO NOTE 1 AS FOLLOWS:

IS:

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 OR 1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

WAS:

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

SEE NCR 08-069 FOR FURTHER DETAILS

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